

Split

Date: Friday, 9/7/2007 10:14:51 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TAIL LIGHT FAIRING
Job Number	: 34463 - 1	Part Number	: D3484042
Estimate Number	: 12418	Drawing Number	: D3484 REV D
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 9/7/2007 S.O. No. : N/A	Drawing Revision	: D
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 9/30/2007
Previous Run	: 34451	Type	: LARGE FAB ASSY
Written By	:	Qty:	10 Um: Each
Checked & Approved By	: <u>07.09.07.</u>		
Comment	: Est Rev.A New Issue 06-05-23 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34842	BASE, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
BASE, RH
Batch: B34457-2

PD 07-12-06 (2)

2.0	D34844	FACE, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
FACE, RH
Batch: B34459

PD 07-12-06 (2)

3.0	D34846	CONE, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
CONE, RH
Batch: B34461-2

PD 07-12-06 (2)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3484 using DT8880 Jig
A/R AL ROD Batch: M106330

2-Buff & Smooth Welds to mating surfaces

PD 07-12-07 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description:

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Mo 7/12/10 (2)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7-12-10 (2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 07/12/10 (2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 07-12-10 (2)

9.0

MS20426AD33

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Rivet

Batch: M1563 X

8.000

FF 07-12-10

2

10.0

MS2106904

ANCHOR NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

ANCHOR NUT

Batch: M19633 X 2

2.000

M103693 X 2

FF 07-10-12

2

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Nut Plates as per Dwg D3484

Handwritten signature/initials

FF 07-12-11

2

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/12/11 (2042)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 5/12/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

POWDER COATING

POWDER COATING



M105914



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9/8

07-12-11

(X2)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(2X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1

07/12/11

15.0

A

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Identify on inside surface as indicated

TCCA-PDA, DART AEROSPACE LTD

P/N: D412-750-142 B/N: BXXXXX

FOR PRODUCT ELIGIBILITY SEE PDA06-13

7/12/11

(2)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

7/12/11

Job Completion



6/12/11

15 B

Inspect level 5

Check P/N To Drawing

check on form 9.5

7/12/11 (2012)

Permanent Change

18

PTO

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07092715B		Inspection level 5. Check P/N To Drawing <u>Permanent Change</u>		/ /		18 25/09/27	18 27/09/27	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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